

5/26

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23527
<b>Description:</b> Bracket	<b>Part Number:</b>	D3209-041
<b>Dwg:</b> D3209 Rev. A	<b>Qty:</b>	10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <b>Dwg not required</b>	HA	05.06.08	10
2	MV	Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B1.500x01.250) <b>Identify for D3209-1</b> Batch: M17037	JL	05/06/20	10
3	MV	Machine D3209-1 as per Folio FA345 and Dwg D3209 <b>Identify as D3209-1</b>	JL	05/06/20	10
4	QC2	Inspect parts as they come off the CNC machine	JL	05/06/20	10
5	MV	Deburr and Tumble	JL	05/06/20	10
6	QC8	Second check	EC	05.06.20	10
7	FP	Chemical conversion Coat as per QSI 005 4.1	ML	05.06.20	10
8	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 <b>Note: Cover the hole for D3209-1 before powder coat.</b>	ML	05.06.20	10
9	QC3	Inspect Powder Coat	J	05.07.06	10
10	GA	Press fit bushing into the bracket as per Dwg D3209 <b>Pick: Packing Kit</b> Qty Part Number Description Batch 1 D3209-3 Bushing 9x B23204 <b>Identify as D3209-041</b> 1x B22081	FF	05.07.15	10
11	QC5	Inspect work to Step 10	2	05.07.18	10
12	ST	Identify and Stock	2	05.07.18	10
13	AC	Cost / part: 35.20	AL	05/07/27	10
14	DC	Close W/O 37.39 Inspect Level 21	FD	05/07/28	10

Rev	Date	Change	Revised By	Approved
A	04.06.09	New issue	KJ/RF	RF

RELEASED

04.06.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/06/20	3	- Wrong part # engraved on 1 only  - 1 piece pushed down in vise piece is too thin	J.L.	<del>W</del> SCRAP: replace	 05-06-20	 05/06/20	 05-06-20	

Part No: D3209-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   
 Date: 05/07/20

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_



# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 07, 2005  
11:54 am

Work Order No : 0023527  
Project Name : D3209-041  
Project For : WK526  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3209-041  
Description : Bracket  
Manufactured : Yes  
Amount Req'd : 3  
Amount Done : 0  
Start Date : 06-07-05  
Est Finish Date : 06-30-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

REFERENCE ONLY

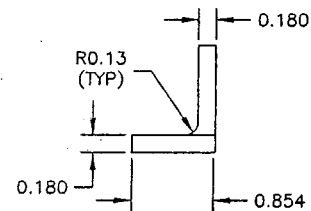
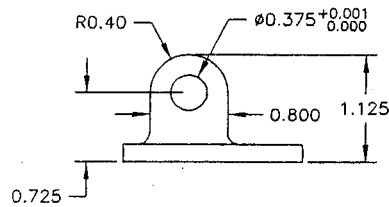
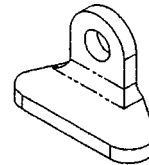
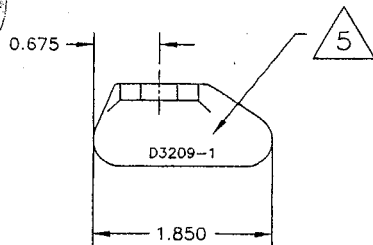
**PART**

COPY ISSUED

CONTROLLED COPY

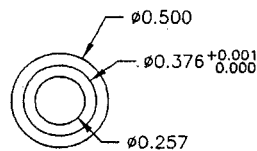
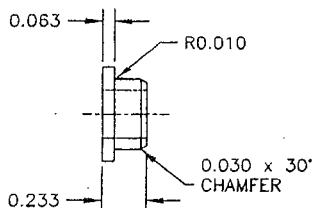
DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED TF	APPROVED TF	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED  
H 04.04.05



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**D3209-1 BRACKET**

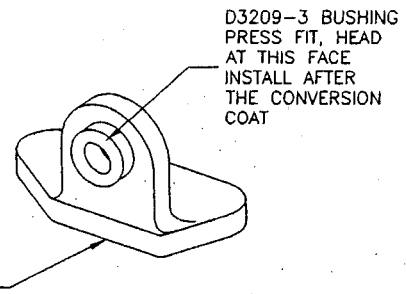


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**D3209-3 BUSHING  
SCALE 1:2**

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**D3209-041 ASSEMBLY**



**D3209-1 BRACKET; D3209-3 BUSHING**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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